

Date: Monday, 1/23/2006 7:51:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET, CLEVIS
 Job Number : 25581
 Estimate Number : 10109
 P.O. Number : N/A Part Number : D2012115
 This Issue : 1/23/2006 S.O. No. : N/A Drawing Number : D2012-115 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 24559 Material : N/A
 Due Date : 2/7/2006 Qty: 100 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est: A 02.09.20 New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 621

Laser cut as per Dwg D2012-115 (Note: 2 parts)

Material release note required

W 06-02-20 100

2.0 D2012115F Bracket, Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 BRACKET, CLEVIS

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206103109 119

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2012-115T1 & T2

206-03-14 (119)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr as required

M.H. M.F. 06/03/21 (119)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:51:33 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, CLEVIS

Job Number: 25581

Part Number: D2012115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2012-115 and bend Jig D2012-115T1

SB 06/03/21

1 part has 115
1 part has 119

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Weld per Dwg D2012-115

Grind flush

06/04/07

Hermine M. 06-05-02 40

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and completeness on the W/O

06/05/10 (11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST117

06/05/10 (11P)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/15 (11)

Job Completion


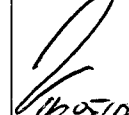





U Dowsell

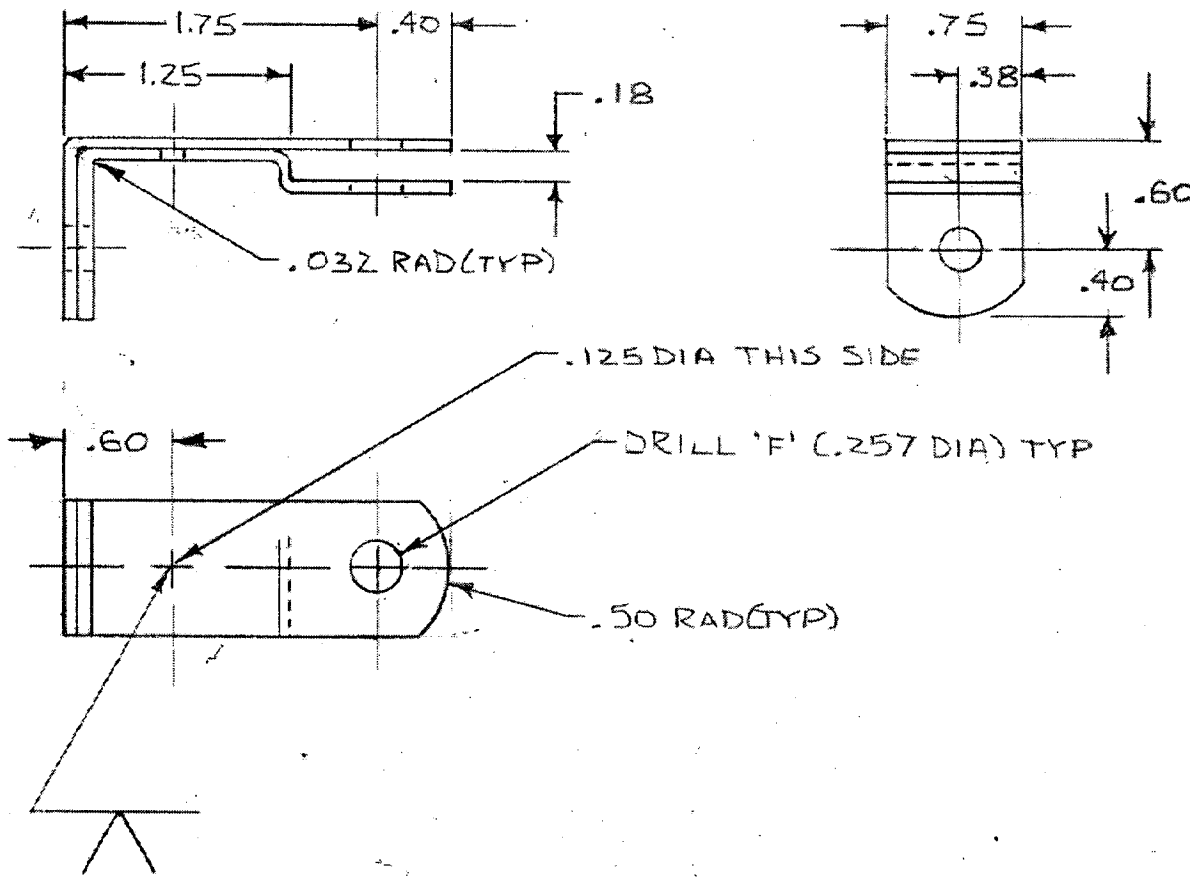
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-10	8	5 parts no good. Holes misaligned, and (2), and 3 were ground to much. Employee's first time.		Scrap: destroy	 06-05-10	 06-05-10		 06-05-10

NOTE: Date & initial all entries



RELEASED
97/08/18 DS

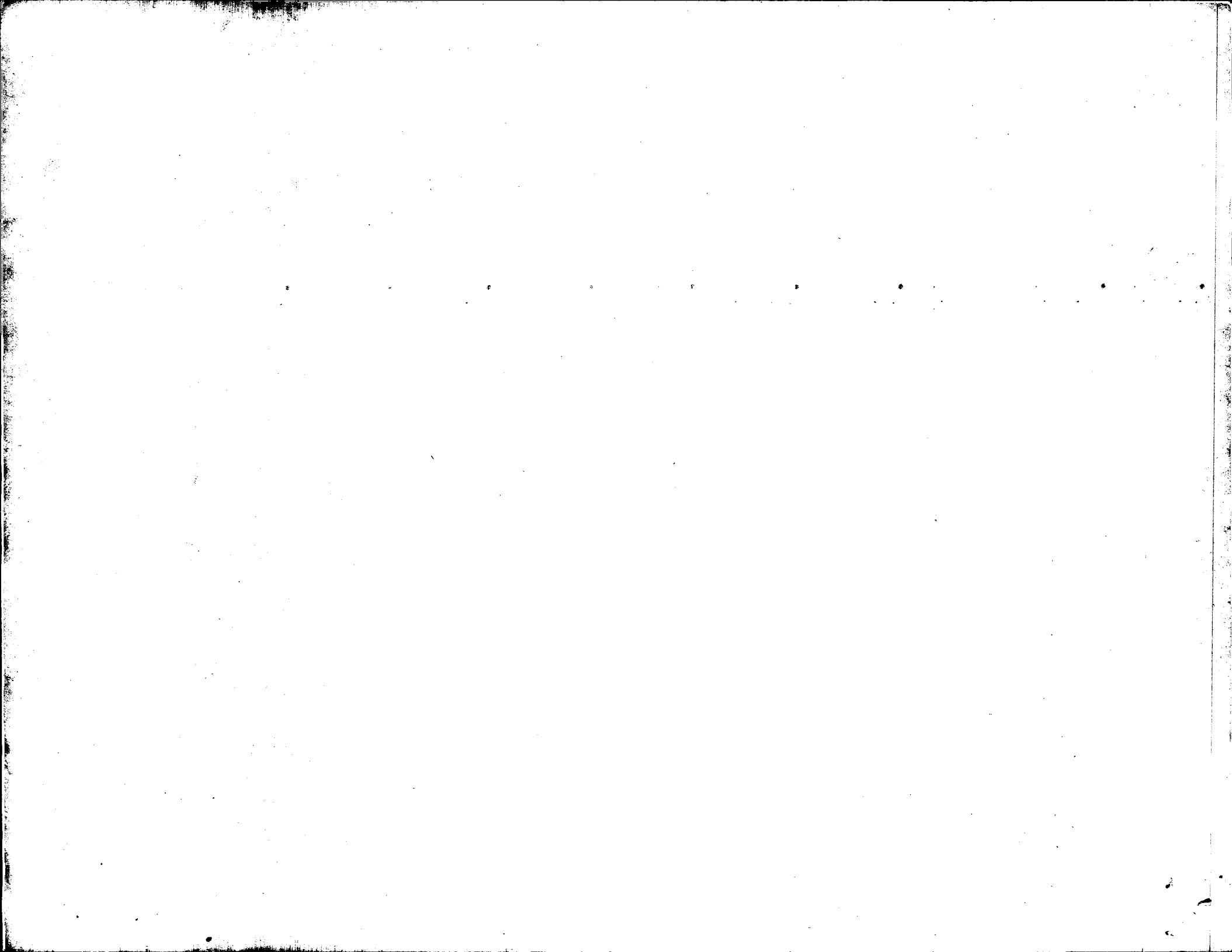
NOTES: 1. MAT'L AISI 304/316 CRES
.063 THICK

D2012-115

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC. / VENDOR
	REVISION		BASIC CODE	DIA. DASH NO. RYHEAD NEAR SIDE RYHEAD FAR SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
	REVISION		QUANTITY SHOWN ON SHEETS C-COUNT REQUIRED	LENGTH DASH NO. W/ SPOTWELD	DRAWN HATTON DATE 04/03/92	TITLE BRACKET			
	REVISION		BASIC CODES		DESIGN BRADLEY STRESS BRADLEY CHECKED BRADLEY (CER)	DATE 7/13/91 11/4/92	REV A		
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 75/10 3. REMOVE SHARP EDGES 0.15 MAX 4. THREADS PER UNC - 2 - 7742 5. HOLES PER ANSI 100.07		1. TOLERANCES - .002 & .030 2. ANGLES 1 M° 3. PARALLELISM .0025 4. PERPENDICULARITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	REPORT ALL DISCREPANCIES - DO NOT SCALE		DWG NO. D2012-115 SCALE FULL		SHEET 1 OF 1		

ENGINEERING
RETURN TO
CUTTING
DEPT
UNCONTROLLED COPY

25581



METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

Corrosion: ASTM A262/01E; 180 Bend-OK

Your Order: V033868

NAS Order: AE 0249852 03

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01, A480/01, A666/00, ASME SA240/01, SA480/01, SA666/01
QQS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	43.68	85.00	88.00

P.O. 621